

Date: Wednesday, 16/01/2008 9:58:21 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 36730	
Estimate Number : 10783	
P.O. Number :	Part Number : D3135041
This Issue : 16/01/2008 S.O. No. :	Drawing Number : D3135 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 36730	Material :
Written By :	Due Date : 10/02/2008 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est: A 03.03.06 New Issue KJ/RF Est Rev:B 08-01-15 now on water jet DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.3150 sf(s)/Unit Total : 1.2600 sf(s)

304/316 .063" thick Sheet

Batch: 106653 IB 8-1-16

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3135

Dwg Rev: C IB 8-1-16

Prog Rev: C

2-Deburr if necessary IB 8-1-16

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-1-16

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6 08/01/16 (4)

5.0	M304TR0375W065	304 RD Tube .375 x .065W
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Comment: Qty.: 0.4375 f(s)/Unit Total : 1.7501 f(s)

304 RD Tube .375 x .065W

Material: AISI 304/316 SS tubing Ø0.375" x 0.065 wall

(M304TR0.375W.065) Annealed

Batch: M18993

FF 08-01-22

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.02.19	8.5	DRILL Ø Ø11(1) Ø0.094 HOLE AS SHOWN ON DWG.	FF	08/02-19	4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.02.19	8.5	holes are off of the above instructions, by 1/2 the hole diameter. 3 parts on 1 of 4 P.L. human error.	<i>[Signature]</i>	Drill hole with weld per as spec. grind flush. re-drill AS per above. change? per chng. Debar.	<i>[Signature]</i> 08.02.26 FF 08/02/26	<i>[Signature]</i> 08.02.22	<i>[Signature]</i> 08.02.19	<i>[Signature]</i> 08.02.19

NOTE: Date & initial all entries

Date: Wednesday, 16/01/2008 9:58:21 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 36730

Part Number: D3135041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr ends

Bend D3135-1 as per template D3135-1T2 and Dwg D3135

Weld handle onto plate as per Dwg D3135 and QSI 004

Scribe Dart P/N as per Dwg D3135

FF 08-01-22 (4)

8/08/02/14 (4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-02-15 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/02/16 (4)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/02/16 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-19 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

8/2/20 se (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 08/02/06 (4)

Job Completion



2008/2/20 (4)

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

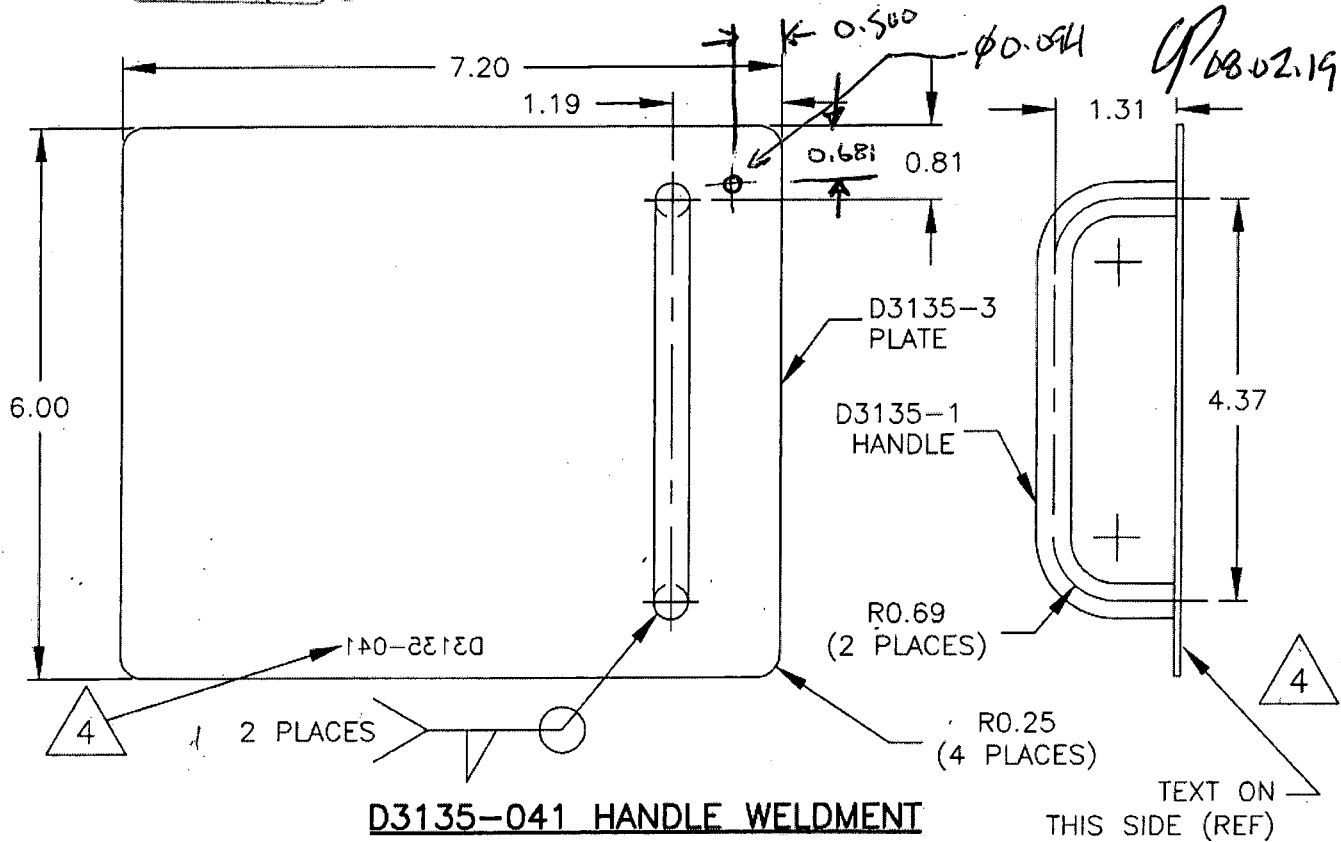
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3135	REV. C SHEET 1 OF 1
DATE 04.10.06	TITLE HANDLE WELDMENT	SCALE 1:2	
A	02.04.17	NEW ISSUE	
B	03.03.04	6.400 WAS 6.330; ADD "ANNEALED"	
C	04.10.06	REMOVED Ø0.221 HOLES	

RELEASED
04.11.23

**D3135-041 HANDLE WELDMENT**

- 1) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-39
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

D3135-1 HANDLE

- 5) MATERIAL: AISI 304/316 SS TUBING Ø0.375 x 0.065 WALL
(REF DART SPEC. M304TR0.375W.065) ANNEALED

D3135-3 PLATE

- 6) MATERIAL: AISI 304/316 SS SHEET 0.063 THICK (REF DART SPEC. M304S16CA)

GENERAL NOTES

- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36730

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